

Work Order ID **139502*****139502***

Page 1

Monday, November 30, 2015 11:45:00 AM

Item ID: D5155-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Co-Pilot Collective Head (Eagle Single)
Start Date: 11/30/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/30/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference: 240

Approvals: Process Plan: ML5 Date: **DEC 02 2015** Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5155	B

100

Cut blanks as per folio

0.00

100

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK AT 5.000"

0.00

B. 15/12/14

4 ⁺	0	DAS 08 9-89
----------------	---	-------------------

110

0.00

110

HAAS 5AXIS

HAAS CNC vertical machine #5

Memo

MACHINE AS PER DWG & FOLIO FB349/ D5155-5

FOLIO REV: AADWG REV: B

0.00

B. 15/12/16

4	10	DAS 08 9-89
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DO NOT BUFF OR POLISH PART

DEBURR

PTO→

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: BAU Date: 16/02/29Work Order update only ☐

Work Order: <u>139502</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D5155-1</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No.		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☒	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Date: 15/12/17 Step #: 110 QTY Effective: 1 MRB (QS1042) Approval
 DAS 9 9-89 16-01-05

Description Work Order Deviation → Program was calling for the wrong offset resulting as damaging 2 of the R.250 close to the φ.627 R.C. folio/Program.	Disposition Scrap + replace <u>M. 133452</u> Folio/program are updated: <u>OFF</u> <u>16/01/05</u>	Completed By <u>BA 15/12/17</u>
		Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>16-01-05</u>
		QC / QA Coordinator Approval DAS 9 9-89 <u>16-01-05</u>

Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☒ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ ☒ Folio/Program Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

Monday, November 30, 2015 11:45:00 AM

Page 1

Work Order ID: 139502

139502

Parent Item: D5155-5

D5155-5

Parent Item Name: Co-Pilot Collective Head (Eagle Single)

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV.A NEW ISSUE JFS 15/01/14 VERIFIED BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.750X03.75 0		Purchased		No		100	f	14.0000	0.417	1.75579			

M6061T6B2 750X03 750

6061-T6 BAR 2.75 X 3.75

5.0 15/12/14

Location

Loc Qty

Loc Code

MAT005

14

→ m127464

2

→ m133452

12

**0.3167 Ft +
1.2625 Ft + 0.4208 Ft**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER :			
Misidentified ☐	☐	Past Due	☐				

DART AEROSPACE LTD		Work Order: 139502
Description: Co - Pilot Collective Head (Eagle single)		Part Number: D5155-5
Inspection Dwg: D5155	Rev: B	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.700	+/- .010	4.698	✓		H-G	31006
2.800	+ .010 / - .000	2.800	✓		"	"
1.75	+/- .030	1.750	✓		"	"
R0.19	+/- .030	R0.188	✓		R-G	ref.
2.047	+/- .010	2.046	✓		H-G	31006
0.35	+/- .030	0.351	✓		Vern	GA-13
14°	+/- 1/2°	14°	✓		Angle M.	CNC-17
φ0.125 X .350	+ .004 / - .001 X +/- .010	φ0.126 X .358	✓		Vern	GA-13
R0.25	+/- .030	R0.250	✓		R-G	ref.
1.870	+/- .010	1.872	✓		H-G	31006
0.227	+/- .010	0.226	✓		"	"
0.33	+/- .030	0.326	✓		Vern	GA-13
0.06	+/- .030	0.061	✓		H-G	31006
0.35	+/- .030	0.351	✓		Vern	GA-13
2.500	+/- .010	2.498	✓		H-G	31006
2.21	+/- .030	2.210	✓		"	"
R0.30	+/- .030	R0.300	✓		R-G	ref.
0.25	+/- .030	0.251	✓		Mic	118-120
R0.25	+/- .030	R0.250	✓		R-G	ref.
1.00	+/- .030	1.004	✓		H-G	31006
1.100	+/- .010	1.103	✓		"	"
φ0.150	+ .005 / - .001	φ0.153	✓		Vern	GA-13
1.500	+/- .010	1.502	✓		H-G	31006
1.100	+/- .010	1.103	✓		"	"
2.500	+/- .010	2.500	✓		Vern	GA-13
1.31	+/- .030	1.312	✓		"	"
0.59	+/- .030	0.592	✓		"	"
R0.25	+/- .030	R0.250	✓		R-G	ref.
R0.30	+/- .030	R0.300	✓		"	"
φ0.150	+ .005 / - .001	φ0.154	✓		Vern	GA-13
0.300	+/- .010	0.301	✓		H-G	31006
1.900	+/- .010	1.900	✓		Vern	GA-13

Measured by: BA	Checked by: 44	QC Inspector:
Date: 15/12/16	Date: 16/02/18	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

DART AEROSPACE LTD		Work Order:	139502
Description: Co-Pilot Collective Head (Eagle Single)		Part Number:	D5155-5
Inspection Dwg: D5155 Rev: B		Page 1 of 1	

INSPECTION SHEET

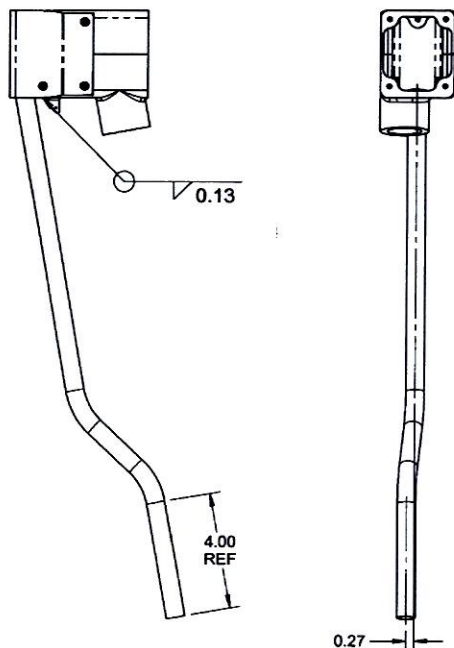
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.16	+/- .030	2.162	✓		H-6	31006
0.38	+/- .030	0.377	✓		"	"
φ0.160	+0.005 / - .001	φ0.162	✓		Vern	GA-13
φ0.500	+0.006 / - .001	φ0.503	✓		"	"
φ0.860 x 0.150	+/- .010 x +/- .010	φ0.864 x .151	✓		"	"
0.254	+0.005 / - .000	0.255	✓		"	"
0.20	+/- .030	0.199	✓		"	"
0.50	+/- .030	0.503	✓		"	"
φ0.627	+0.008 / - .001	φ0.628	✓		Vern	GA-13
1.25	+/- .030	1.250	✓		H-6	31006
0.46	+/- .030	0.460	✓		"	"
3.70	+/- .030	3.700	✓		"	"
0.830	+/- .010	0.830	✓		"	"
φ1.660	+/- .010	φ1.658	✓		Mic	GA-02
φ1.187	+0.005 / - 0.000	φ1.190	✓		Mic / T-6	GA-02 / ref.
0.100	+/- .010	0.100	✓		Mic	GA-03
R0.03	+/- .030	R0.032	✓		R-6	ref.
0.55	+/- .030	0.549	✓		H-6	31006
0.35	+/- .030	0.348	✓		"	"
1.06	+/- .030	1.060	✓		"	"
0.13	+/- .030	0.126	✓		"	"
0.57	+/- .030	0.572	✓		"	"
R0.06	+/- .030	R0.063	✓		R-6	ref.
φ0.0605	+/- .0005	φ0.0605	✓		Mic / G-P	GA-03 / ref.
R0.09	+/- .030	R0.088	✓		R-6	ref.
R0.30	+/- .030	R0.300	✓		"	"
R0.25	+/- .030	R0.250	✓		"	"
1.100	+/- .010	1.102	✓		H-6	31006

Measured by: GA	DAS 08 9-89	Checked by: 44 9-89	QC Inspector:
Date: 15/12/16		Date: 16/02/18	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
2	1	D4410-7	CONDUIT
3	1	D5155-1	CO-PILOT COLLECTIVE HEAD (205)
4	1	D5155-9	CO-PILOT COLLECTIVE HEAD (205)
5	1	D5156-9	BACK PLATE
6	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	2	MS16562-223	SLOTTED SPRING PIN
8	7	MS24693-24B	SCREW, CSK 100"

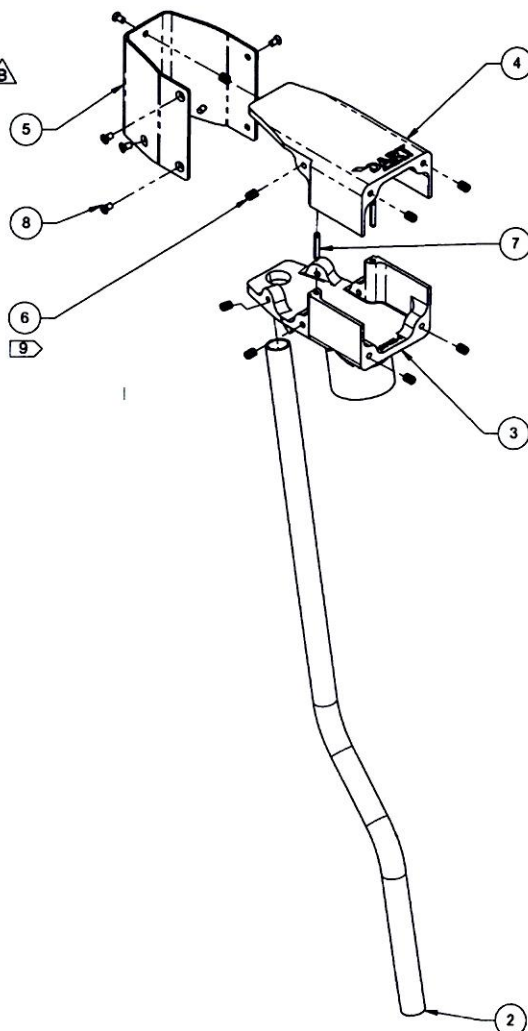


D5155-041 WELDING DETAIL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.08 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

D5155-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 139502 MCJ
15-12-02

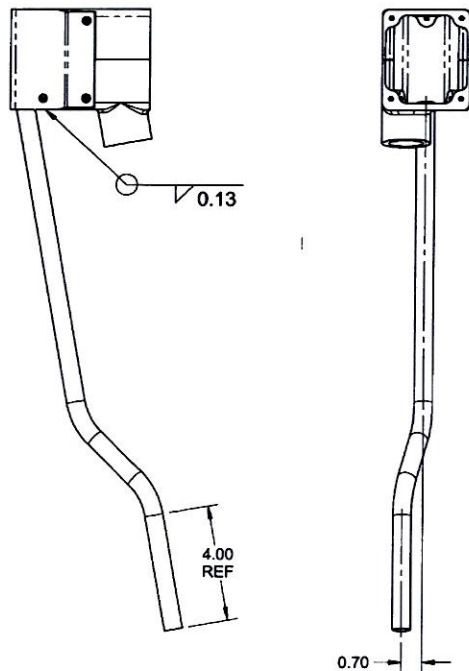
RELEASED

A.P. 2015 JUL 02 Rev 15-577

B	REVISE DIM; ZN D3-7, REVISE NOTE 2; ZN A8-13, A8-14, REVISE LENGTH OF PIN; ZN D6-1, D6-2, D5-3, D5-4, REVISE DEPTH; ZN C7-5, C7-7, C7-9, C7-11, C5-13, C4-14, REVISE DIM; ZN C7-5, C7-7, C7-9, C6-11, B7-13, B7-14, B2-5, B2-7, B2-9, B2-11, C5-13, C4-14, D8-6, D8-8, D8-10, D5-6, D5-8, D5-10, D5-12, B6-7, D7-12, C7-5, C7-7, C7-9, C6-11, D2-13, D2-14	VS	15.05.21
A	NEW ISSUE	VS	14.09.10
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 1 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
2	1	D4410-7	CONDUIT
3	1	D5155-3	CO-PILOT COLLECTIVE HEAD (212)
4	1	D5155-11	CO-PILOT COLLECTIVE HEAD (212)
5	1	D5156-11	BACK PLATE
6	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	2	MS16562-223	SLOTTED SPRING PIN
8	7	MS24693-24B	SCREW, CSK 100*

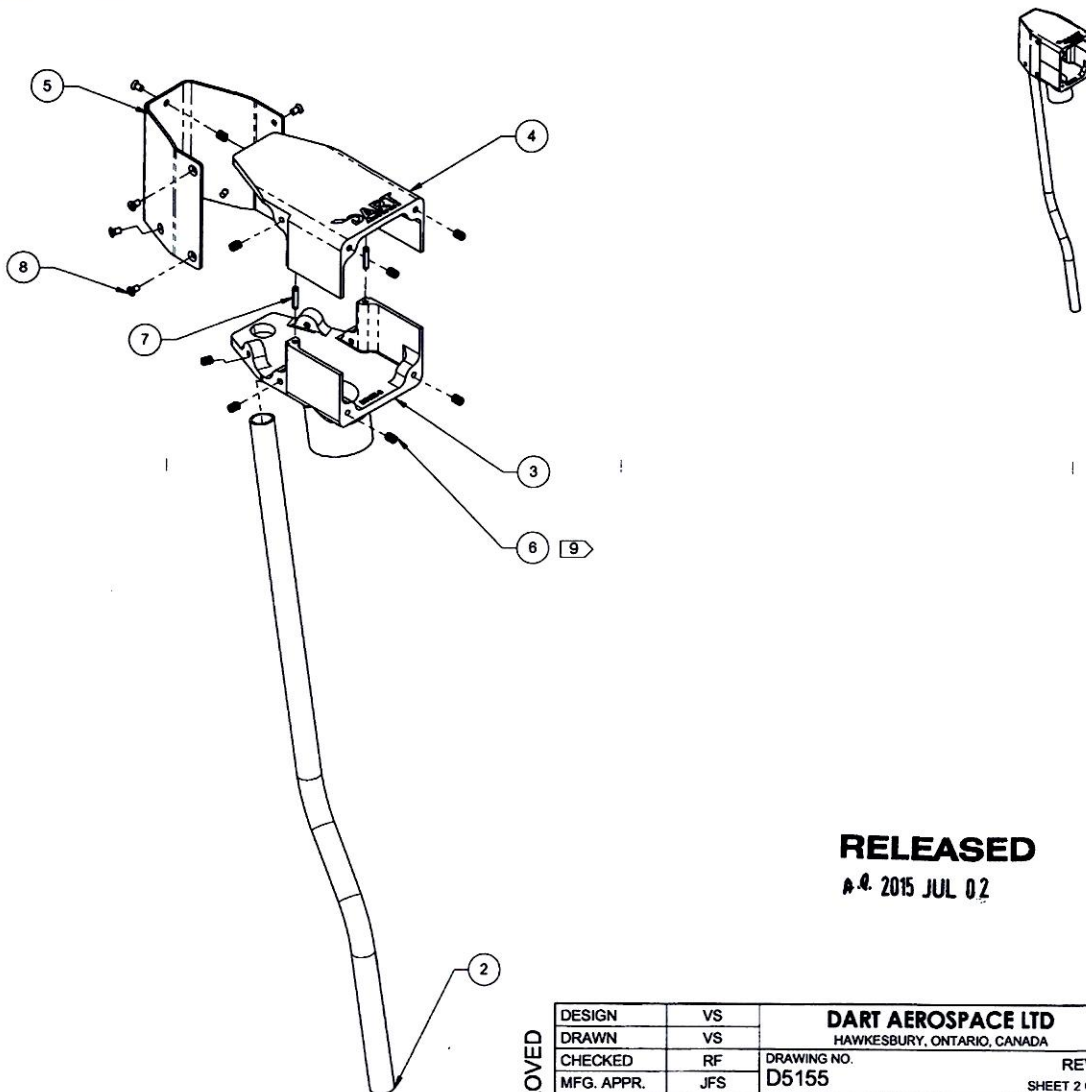


D5155-043 WELDING DETAIL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.20 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

D5155-043 CO-PILOT COLLECTIVE HEAD ASSY (212)



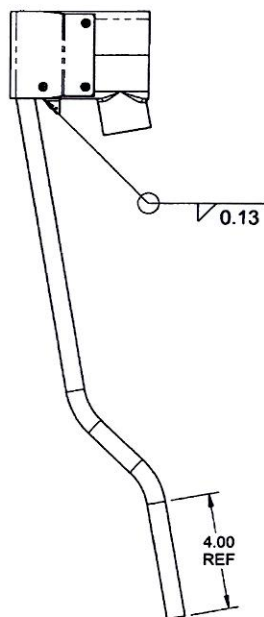
RELEASED

14 JUL 2015

APPROVED

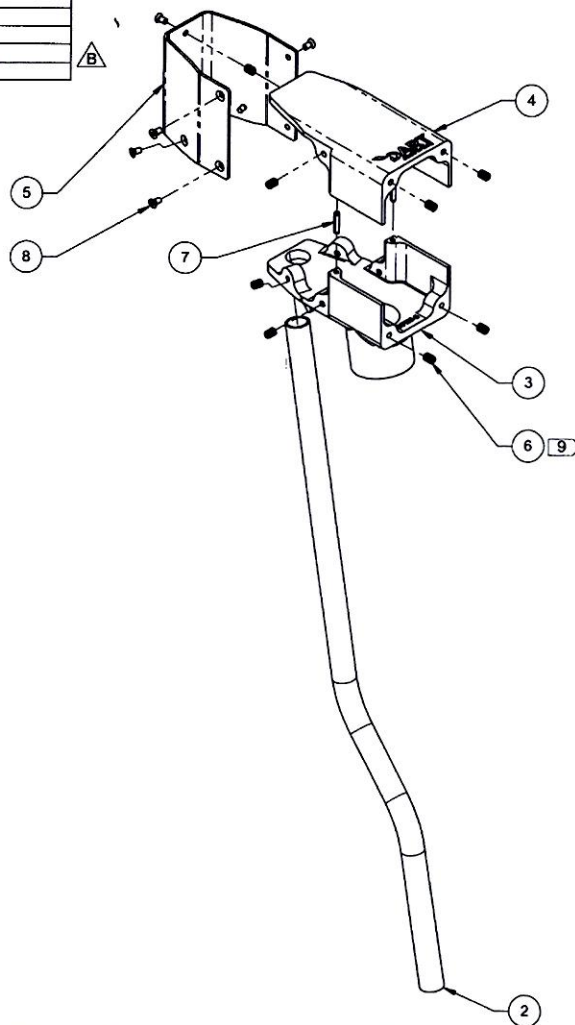
DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 2 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
2	1	D4410-7	CONDUIT
3	1	D5155-5	CO-PILOT COLLECTIVE HEAD (EAGLE SINGLE)
4	1	D5155-9	CO-PILOT COLLECTIVE HEAD (205)
5	1	D5156-9	BACK PLATE
6	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	2	MS16562-223	SLOTTED SPRING PIN
8	7	MS24693-24B	SCREW, CSK 100*



D5155-045 WELDING DETAIL

0.27



D5155-045 CO-PILOT COLLECTIVE HEAD ASSY (EAGLE SINGLE)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.06 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

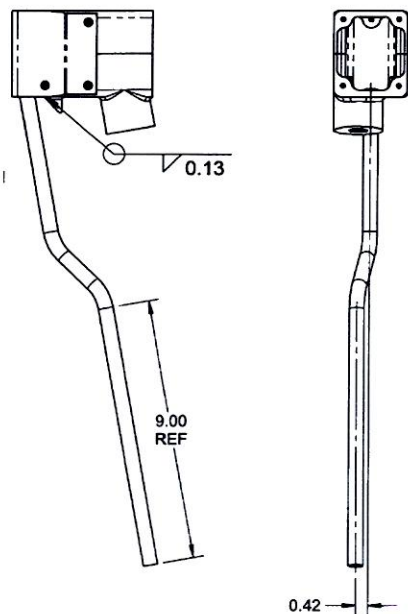
APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 3 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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15 JUL 02

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-047	CO-PILOT COLLECTIVE HEAD ASSEMBLY
2	1	D5054-1	CONDUIT
3	2	D5073-1	SNAP RING
4	1	D5155-7	CO-PILOT COLLECTIVE HEAD (205)
5	1	D5155-9	CO-PILOT COLLECTIVE HEAD (205)
6	1	D5156-9	BACK PLATE
7	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
8	2	MS16562-223	SLOTTED SPRING PIN
9	7	MS24693-24B	SCREW, CSK 100°
10	1	MS27641-3	BEARING

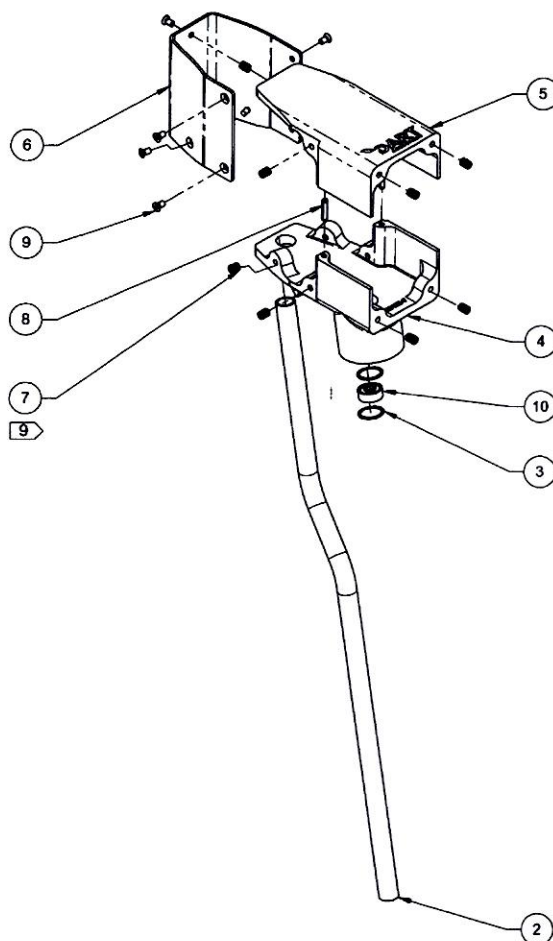


D5155-047 WELDING DETAIL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.14 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

**D5155-047 CO-PILOT COLLECTIVE HEAD ASSY
FOR 205 WITH 204-001-290-5 STICK AND THROTTLE ASSEMBLY INSTALLED**

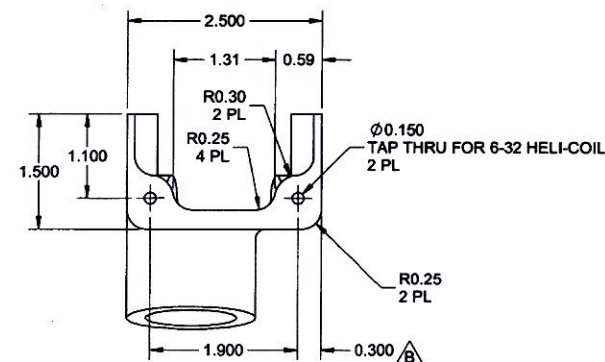
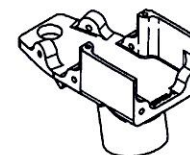
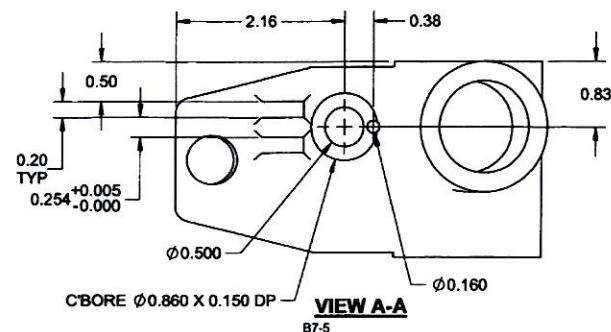


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15 JUL 02

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DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 4 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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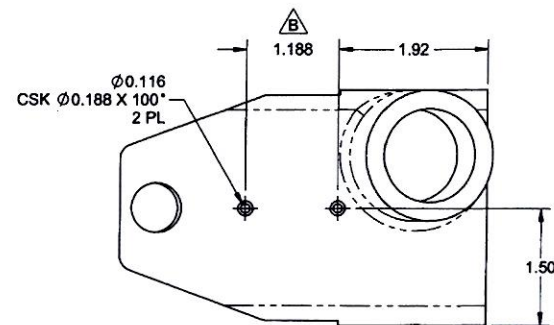
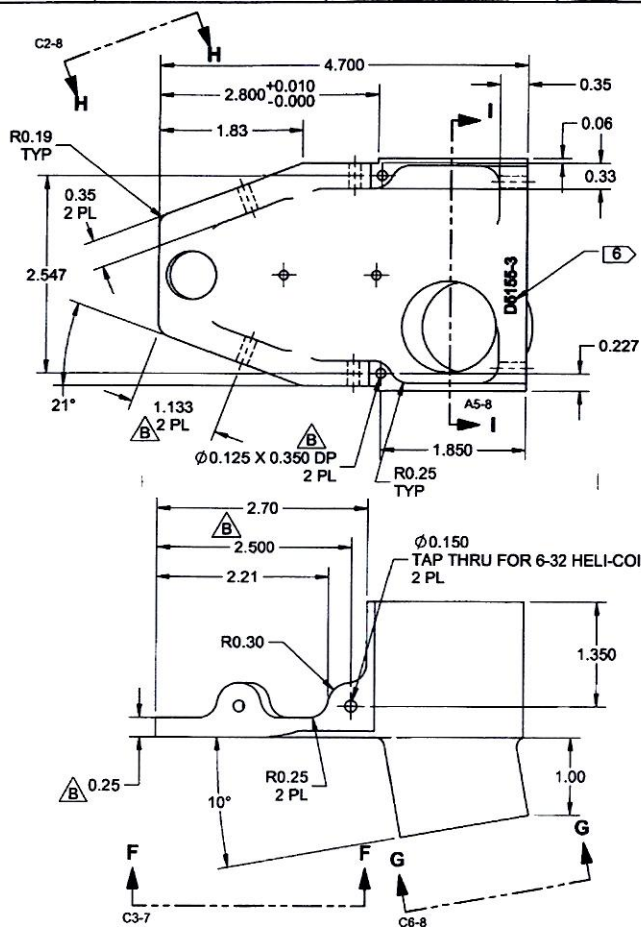
2) FINISH: NONE
3) TOLERANCES: PER DART Q018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER Q044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
7) WEIGHT: 0.47 lbs
8) UNDIMENSIONED FEATURES ARE DEFINED BY D5155-1.SLDPRT

D5155-1 CO-PILOT COLLECTIVE HEAD (205)

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5155 TITLE CO-PILOT COLLECTIVE HEAD COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. B
	DRAWN	VS		SHEET 5 OF 14
	CHECKED	RF		
	MFG. APPR.	JFS		
	APPROVED	HS		SCALE
	DE APPR.	DS		NTS
	DATE	15.05.21		

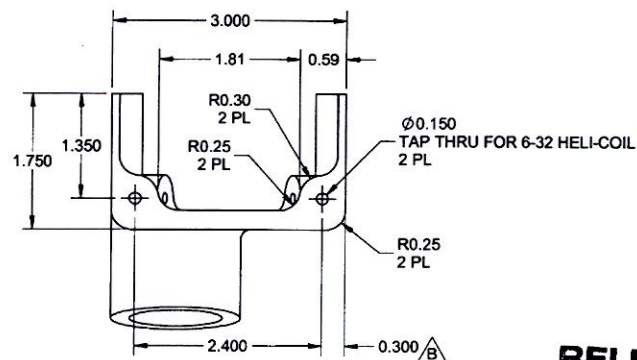


DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. B D5155 TITLE SCALE CO-PILOT COLLECTIVE HEAD NTS COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND NOT BE LOANED, REPRODUCED OR COPIED IN ANY MANNER IF IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR CONVEYANCE TO ANY OTHER PERSONS WITHOUT THE WRITTEN PERMISSON OF DART AEROSPACE LTD.
DRAWN	VS	
CHECKED	RF	
MFG. APPR.	JFS	
APPROVED	HS	
DE APPR.	DS	
DATE	15.05.21	



VIEW F-F

B7-7



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A.P. 2015 JUL 02

NOTES:

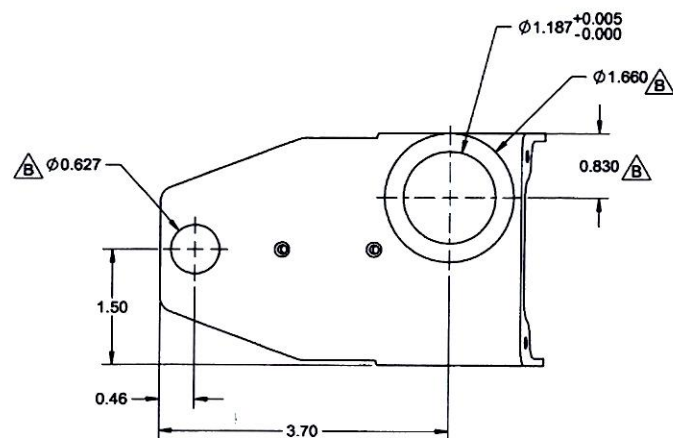
- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.51 lbs
- 8) UNDIMENSIONED FEATURES DEFINED BY D5155-3.SLDPR

D5155-3 CO-PILOT COLLECTIVE HEAD (212)

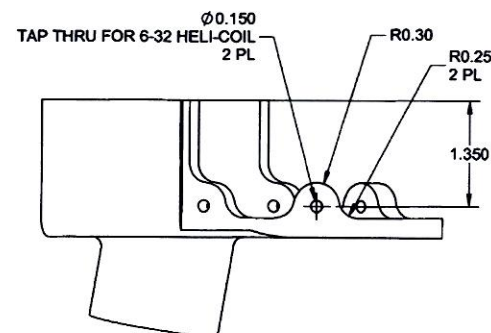
APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 7 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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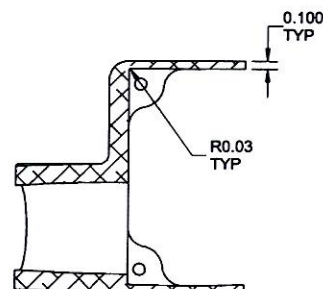
8 7 6 5 4 3 2 1



VIEW G-G
B6-7



VIEW H-H
D7-7



SECTION I-I
D6-7

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A.9.2015 JUL 02

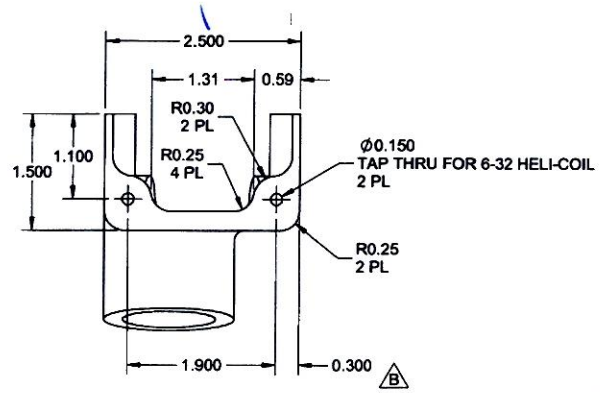
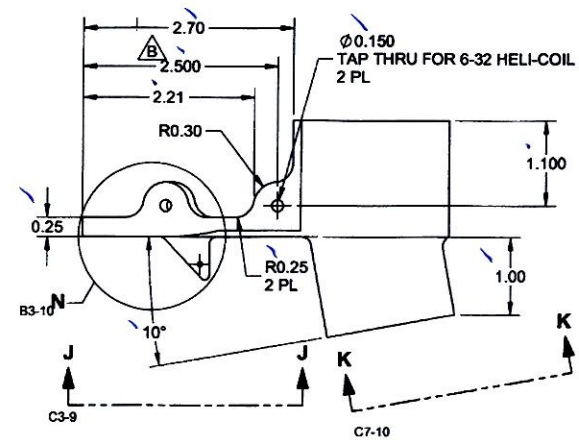
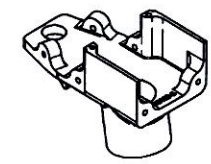
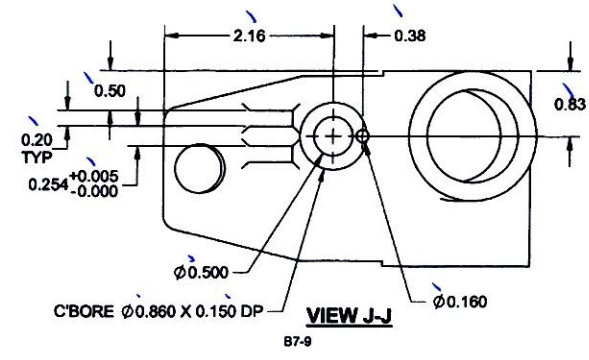
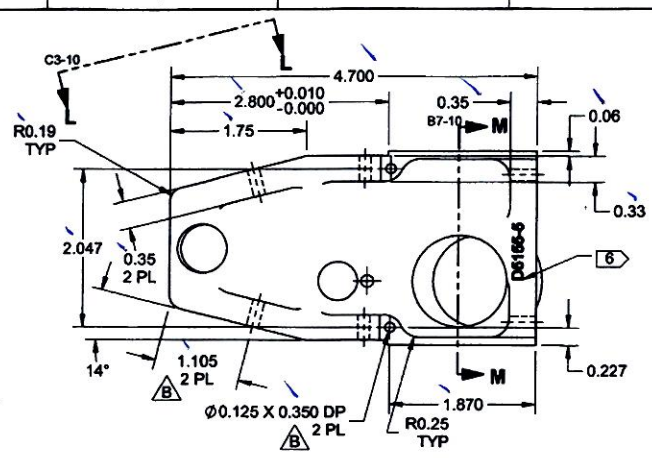
- NOTES:**
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

D5155-3 CO-PILOT COLLECTIVE HEAD (212)
DETAIL VIEWS

APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 8 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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8 7 6 5 4 3 2 1

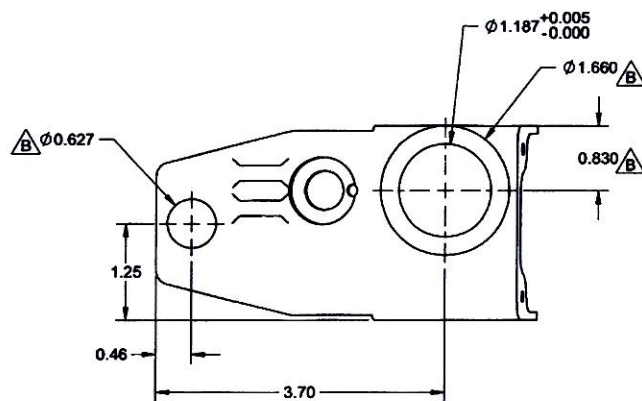


- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
 - 7) WEIGHT: 0.45 lbs
 - 8) UNDIMENSIONED FEATURES DEFINED BY D5155-5.SLDPRT

D5155-5 CO-PILOT COLLECTIVE HEAD (EAGLE SINGLE)

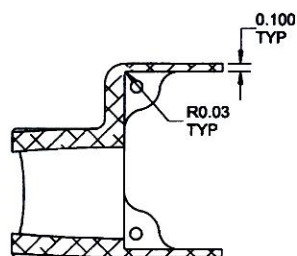
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A.O. 2015 JUL 02

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D5155	SHEET 9 OF 14
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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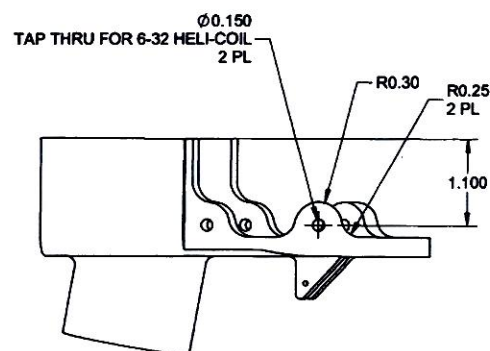
VIEW K-K

B6-9



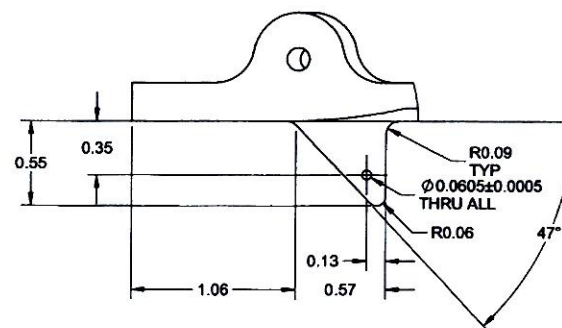
SECTION M-M

D6-9



VIEW L-L

D7-9



DETAIL N

B7-9

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4.9. 2015 JUL 02

NOTES:

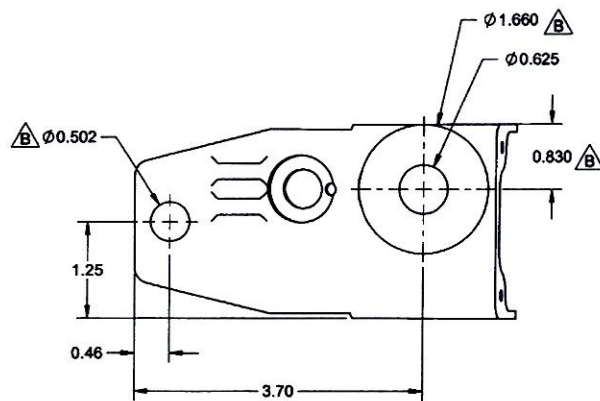
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

D5155-5 CO-PILOT COLLECTIVE HEAD (EAGLE SINGLE)

DETAIL VIEWS

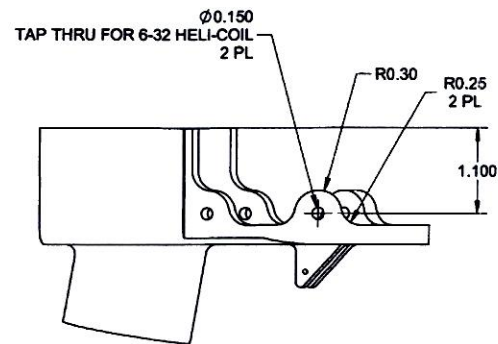
APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 10 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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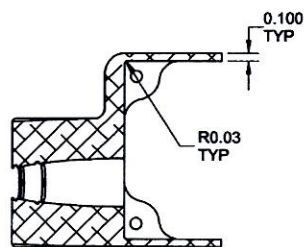
VIEW P-P

B5-11



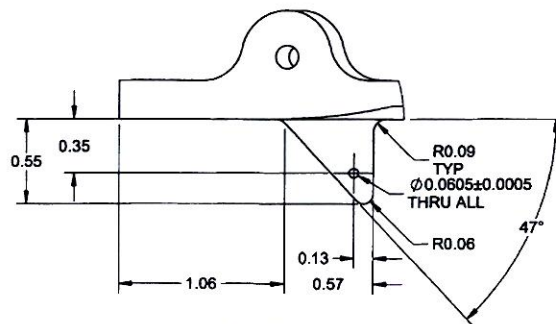
VIEW Q-Q

D7-11



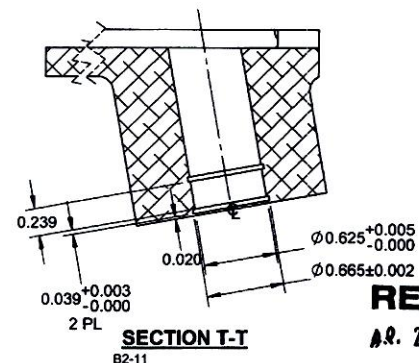
SECTION R-R

C6-11



DETAIL S

B6-11



SECTION T-T

B2-11

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A.R. 2015 JUL 02

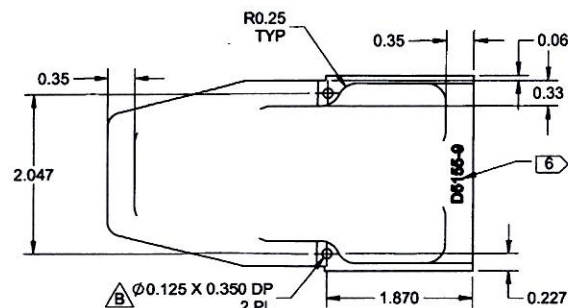
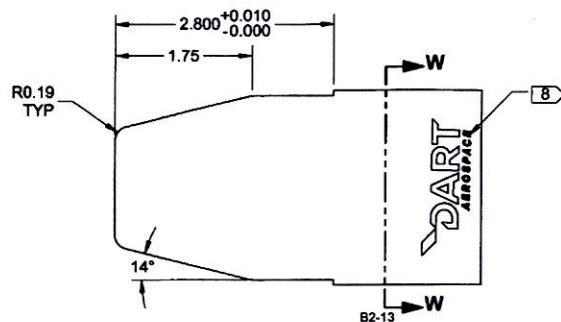
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

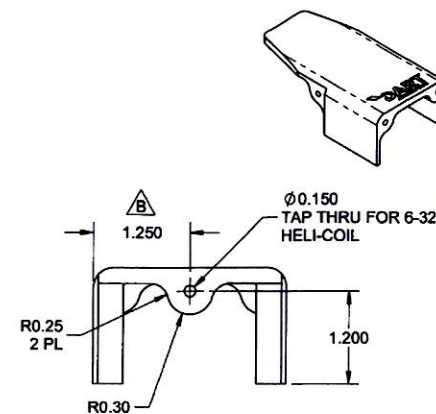
D5155-7 CO-PILOT COLLECTIVE HEAD (205)
DETAIL VIEWS

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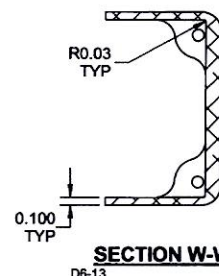
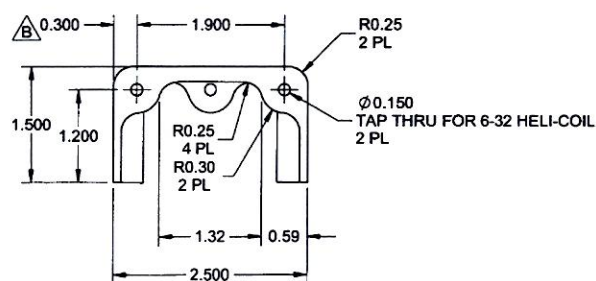
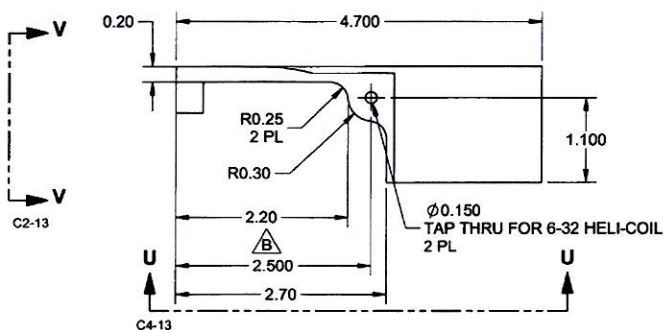
DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 12 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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VIEW U-U
B7-13



VIEW V-V
B8-13



RELEASED
4.8.2015 JUL 02

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II
OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.31 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP
- 9) UNDIMENSIONED FEATURES DEFINED BY D5155-9.SLDPRT

D5155-9 CO-PILOT COLLECTIVE HEAD (205)

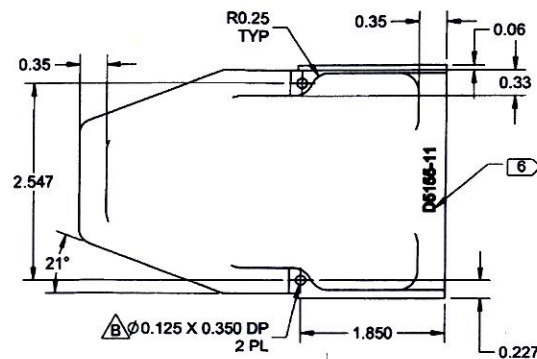
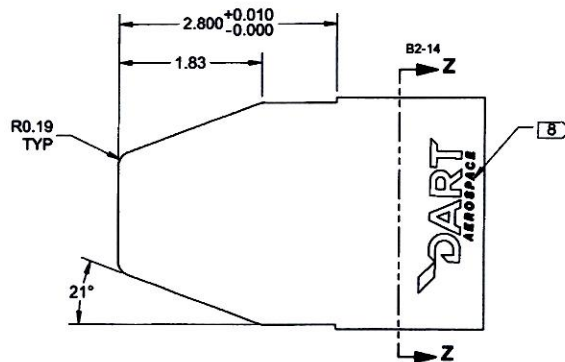
APPROVED

DESIGN	VS
DRAWN	VS
CHECKED	RF
MFG. APPR.	JFS
APPROVED	HS
DE APPR.	DS
DATE	15.05.21

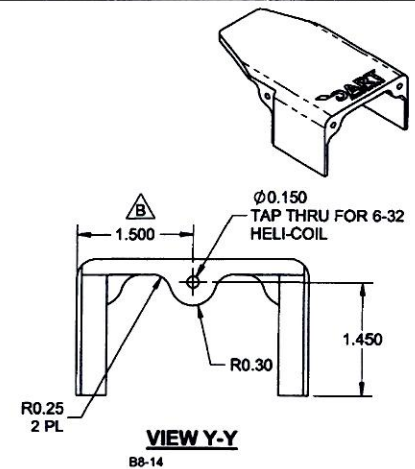
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D5155
SHEET 13 OF 14
SCALE
CO-PILOT COLLECTIVE HEAD NTS

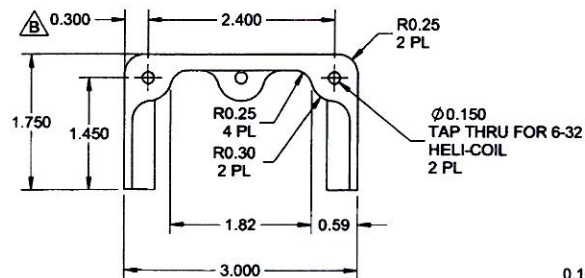
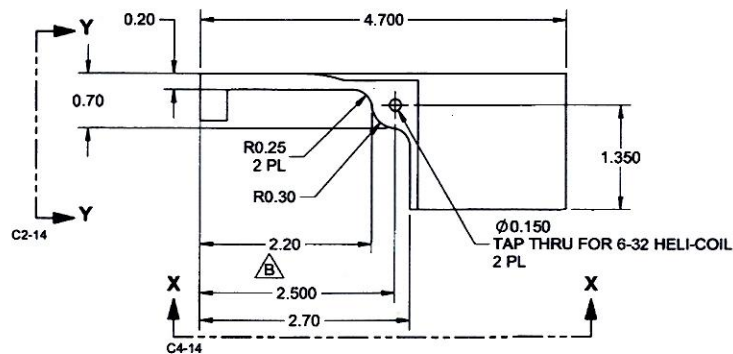
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VIEW X-X
B6-14



VIEW Y-Y
B8-14



SECTION Z-Z
D6-14

RELEASED

15 JUL 02

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4118)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II
OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.36 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP
- 8) UNDIMENSIONED FEATURES DEFINED BY D5155-11.SLDPRT

D5155-11 CO-PILOT COLLECTIVE HEAD (212)

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D5155	SHEET 14 OF 14
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	
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Part Number: D5155-5	Rev: B	- Page 1 -
Description: CO-PILOT COLLECTIVE	Inspection Dwg: D5155	Work Order: 139502

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	1. No. Piece_4 Actual	
1	0.1890	+0.0300/-0.0300	0.1891	0.1886	0.1891	0.1887	
2	2.8000	+0.0100/0.0000	2.8000	2.8000	2.8000	2.8000	
3	4.7000	+0.0100/-0.0100	4.6976	4.6983	4.6979	4.6981	
D4	0.3500	+0.0300/-0.0300	0.3500	0.3500	0.3500	0.3500	
5	0.0600	+0.0300/-0.0300	0.0633	0.0630	0.0625	0.0631	
D6	0.3300	+0.0300/-0.0300	0.3270	0.3300	0.3270	0.3300	
D7	0.2270	+0.0050/-0.0050	0.2270	0.2270	0.2270	0.2270	
D8	1.8700	+0.0100/-0.0100	1.8700	1.8700	1.8700	1.8700	
D9	0.1250	+0.0040/-0.0010	0.1250	0.1250	0.1250	0.1250	
10	14.0000	+0.5000/-0.5000	14.1005	14.0758	14.0811	14.0450	
D11	0.3500	+0.0300/-0.0300	0.3500	0.3500	0.3500	0.3500	
D12	2.0470	+0.0050/-0.0050	2.0470	2.0470	2.0470	2.0470	
13	0.5000	+0.0300/-0.0300	0.5037	0.5042	0.5050	0.5046	
14	2.1600	+0.0300/-0.0300	2.1596	2.1594	2.1598	2.1600	
15	0.3800	+0.0300/-0.0300	0.3749	0.3753	0.3746	0.3750	
16	0.8300	+0.0300/-0.0300	0.8313	0.8308	0.8304	0.8308	
17	0.1600	+0.0050/-0.0010	0.1648	0.1632	0.1631	0.1644	
18	0.1500	+0.0100/-0.0100	0.1500	0.1501	0.1501	0.1499	
19	0.8600	+0.0100/-0.0010	0.8630	0.8631	0.8630	0.8632	
20	0.5000	+0.0060/-0.0010	0.5026	0.5026	0.5023	0.5024	
21	0.2540	+0.0050/0.0000	0.2542	0.2542	0.2541	0.2540	
22	0.2000	+0.0300/-0.0300	0.1996	0.1994	0.1993	0.1994	
23	2.5000	+0.0100/-0.0100	2.5002	2.5003	2.5002	2.5003	
24	0.1500	+0.0050/-0.0010	0.1550	0.1549	0.1548	0.1550	
R0.25	0.2500	+0.0300/-0.0300	0.2499	0.2500	0.2497	0.2499	
26	0.3000	+0.0050/-0.0050	0.2992	0.2997	0.2998	0.3000	
27	1.9000	+0.0050/-0.0050	1.9000	1.8999	1.8995	1.8993	
R0.25	0.2500	+0.0300/-0.0300	0.2515	0.2510	0.2514	0.2513	
29	0.3000	+0.0300/-0.0300	0.3034	0.3030	0.3029	0.3031	
30	1.5000	+0.0100/-0.0100	1.4961	1.5023	1.5019	1.5029	
31	1.1000	+0.0100/-0.0100	1.0952	1.1012	1.1011	1.1014	

Measured by:
Mathieu Lamarche

Date:
2016-2-17

Audited by:

DAS
44
9-89

Date:

16/02/18



Part Number: D5155-5	Rev: B	- Page 2 -
Description: CO-PILOT COLLECTIVE	Inspection Dwg: D5155	Work Order: 139502

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	1. No. Piece_4 Actual	
32	2.7000	+0.0300/-0.0300	2.6985	2.6987	2.6986	2.6978	
33	2.5000	+0.0100/-0.0100	2.4966	2.4969	2.4974	2.4967	
34	0.3000	+0.0300/-0.0300	0.3023	0.3015	0.3022	0.3020	
35	0.1500	+0.0050/-0.0010	0.1536	0.1532	0.1520	0.1545	
36	1.1000	+0.0100/-0.0100	1.0956	1.1020	1.1013	1.1021	
D37	1.0000	+0.0050/-0.0050	1.0030	1.0010	1.0000	1.0000	
38	0.2500	+0.0300/-0.0300	0.2517	0.2497	0.2510	0.2503	
D39	0.2500	+0.0300/-0.0300	0.2530	0.2530	0.2530	0.2500	
40	0.6270	+0.0080/-0.0010	0.6278	0.6284	0.6284	0.6272	
41	1.1870	+0.0050/0.0000	1.1894	1.1894	1.1894	1.1893	
1.660	1.6600	+0.0100/-0.0100	1.6574	1.6575	1.6575	1.6579	
43	0.8300	+0.0100/-0.0100	0.8298	0.8300	0.8300	0.8298	
44	3.7000	+0.0300/-0.0300	3.6991	3.6996	3.6994	3.6986	
45	0.4600	+0.0300/-0.0300	0.4562	0.4563	0.4563	0.4565	
46	1.2500	+0.0300/-0.0300	1.2513	1.2507	1.2505	1.2516	
47	0.1000	+0.0100/-0.0100	0.1004	0.1007	0.1006	0.1008	
48	0.1500	+0.0050/-0.0010	0.1507	0.1544	0.1545	0.1538	
49	0.3000	+0.0300/-0.0300	0.3010	0.3010	0.3010	0.3010	
50	0.2500	+0.0300/-0.0300	0.2500	0.2499	0.2499	0.2501	
51	1.1000	+0.0100/-0.0100	1.0966	1.1028	1.1024	1.1030	
D52	0.0900	+0.0300/-0.0300	0.0620	0.0630	0.0630	0.0620	
53	0.0605	+0.0005/-0.0005	0.0600	0.0610	0.0610	0.0602	
54	47.0000	+0.5000/-0.5000	46.9369	46.9587	46.9494	46.9358	
55	0.0600	+0.0300/-0.0300	0.0580	0.0582	0.0580	0.0580	
56	0.1250	+0.0300/-0.0300	0.1275	0.1275	0.1278	0.1279	
57	0.5500	+0.0300/-0.0300	0.5481	0.5482	0.5482	0.5482	
58	0.3500	+0.0300/-0.0300	0.3496	0.3491	0.3490	0.3487	

Measured by:
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